

# Work Order ID 117307

**\*117307\***

Page 1

June-16-14 10:54:34 AM

Item ID: D4805-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: End Fitting  
Start Date: 6/16/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 6/16/14 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference: PART MARKING

Approvals: Process Plan: MLT Date: 1406-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4805	REV A

102		0.00							
<b>*102*</b>									
Purchasing	Memo	0.00							
Purchasing	PULL FROM STK: 2 X D4805-3 B112023 SEND TO P & L PRINTING FOR PART MARKING PO <u>24622</u>								
105	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*105*</b>									
Packaging	Memo	0.00							
Packaging									
110	QC6- Inspect dimensions to drawing	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

CZ 14100117

*N/A already approved on HaaS*

R 14/6/14

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Page 2

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 Start Date: 6/16/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference: PART MARKING

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Identify as per dwg & Stock Location: _____	0.00							
*115*									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

*Handwritten signature*  
 140620

# Picklist Print

Page 1

June-16-14 10:54:34 AM

Work Order ID: 117307

**\*117307\***

Parent Item: D4805-3

**\*D4805-3\***

Parent Item Name: End Fitting

Start Date: 6/16/14

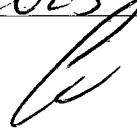
Required Date: 6/16/14

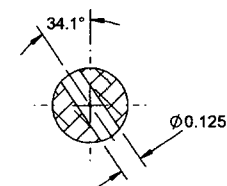
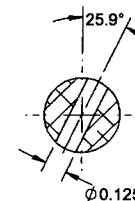
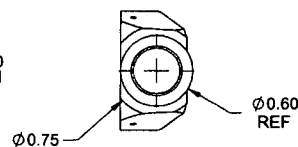
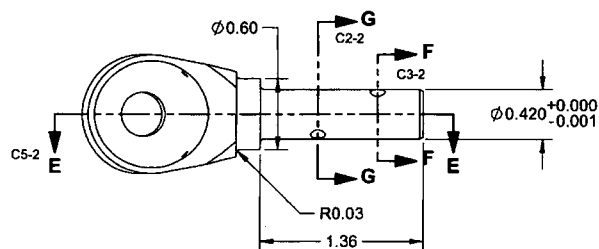
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4805-3		Manufactured	No				Each	0.0000		2			
<b>*D4805-3*</b>									<b>**</b>				
End Fitting													

112023  




**SECTION F-F** 85-2

**SECTION G-G** B6-2

### **D4805-3 END FITTING**

1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R

2). FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) <sup>i</sup>BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.

8) IDENTIFICATION: IDENTIFY PER QST 044 6.5.  
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010

7) WEIGHT: 0.13 lbs

8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 117307 M

1406-16

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA  DRAWING NO. <b>D4805</b>  TITLE <b>END FITTING</b>  COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT AND ALL INFORMATION HEREIN IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR PURPOSES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. A
DRAWN	RF		SHEET 2 OF 2
CHECKED	HS		SCALE
MFG. APPR.	JLM		NTS
APPROVED	HS		
DE APPR.	DS		
DATE 13.12.16			